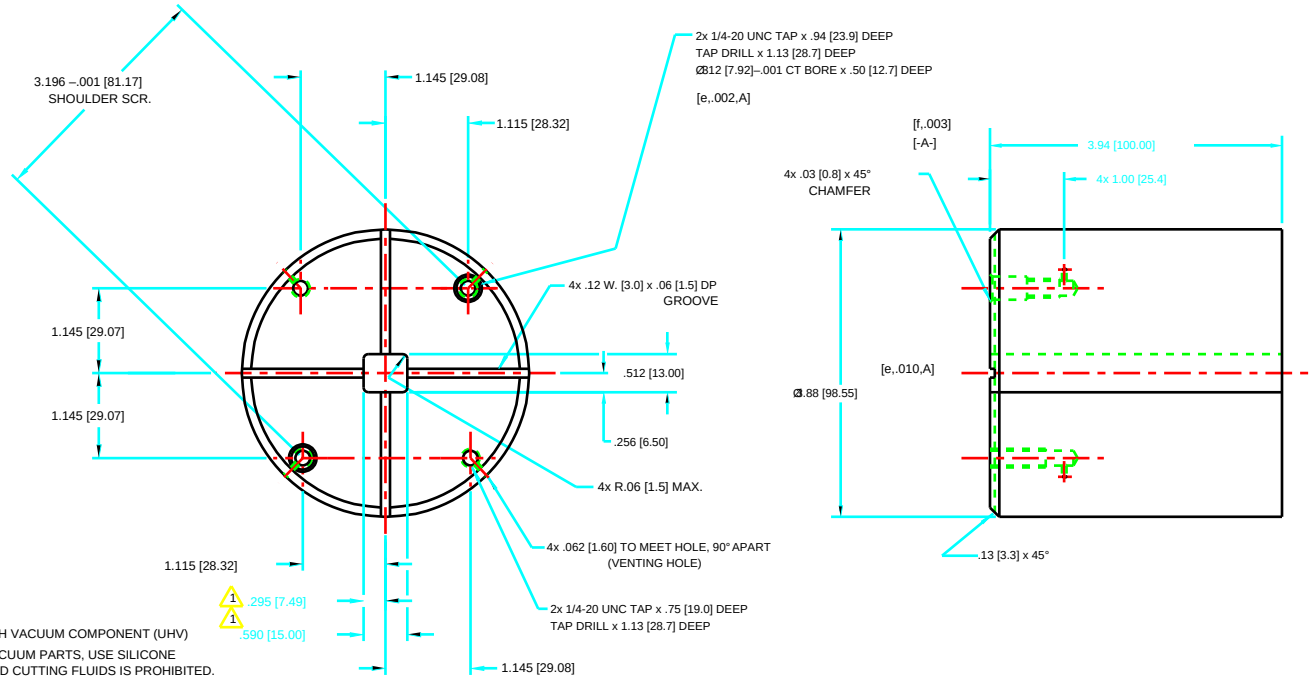
(℄	PLOT SCALE: 1=1	DWG. SCALE: 1	A2138701



NOTES:

1. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
2. WHEN MACHINING VACUUM PARTS, USE SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
   A) CIMCOOL 5 STAR 49
   B) TRIM SOL
3. ALL SURFACES MUST BE MACHINED FOR CLEAN UP
4. TUNGSTEN ALLOY OF 95% TUNGSTEN OR MORE WITH REMAINDER OF NICKEL AND IRON
5. FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
6. CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT A UHV PRESSURE OF 1 X 10 -9 TORR CAN BE ACHIEVED
7. HANDLING: THE COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM FOIL TYPE DRY ANNEAL AND UNDER CLEAN ROOM CONDITIONS
8. BREAK ALL SHARP CORNERS 0.03
9. DIMENSIONS IN [ ] ARE MILLIMETERS AND FOR REF. ONLY
10. SURFACE ROUGHNESS 63

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
1	.590 WAS .788;.295 WAS .394;	J.G.	J.C.	6/15/95

REVISIONS

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY

PARTS LIST

UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES
TOLERANCES
DECIMALS: .X ± .03; .XX ± .01; .XXX ± .005
ANGULAR ± .25°
SURFACE ROUGHNESS 125
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5
DO NOT SCALE DRAWING

LOG NUMBER: A2138701

THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY

DRAWN BY: J.GOGOL	DATE: 11/8/94	CHIEF DESIGN ENGINEER: D.SHU	DATE: 1/18/95
CHECKED BY: J.CHANG	1/13/95	GP LEADER: T.M.KUZAY	1/18/95
DESIGNER: J.GOGOL	11/8/94	PROJECT MGR.:	
RESPONSIBLE ENGINEER: J.CHANG	1/13/95	APPROVED/RELEASED	

TITLE: ADVANCED PHOTON SOURCE
P9-30 INTEGRAL SHUTTER (D)
TUNGSTEN BLOCK

MATERIAL: SEE NOTE #4

SCALE: 1:1 SHEET 1 of 1

SIZE: C

DRAWING NUMBER: P4105090909-300001-01

Plotted: JUN 20,1995 2:08 PM